

Date: Tuesday, 23/12/2008 10:25:34 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 44272		Part Number	: D2804042	
Estimate Number	: 10334		Drawing Number	: D2804 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 23/12/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 23/12/2008 Qty: <i>✓</i>	
Previous Run	: 41675		Um:	Each	
Written By	<i>✓</i>				
Checked & Approved By	<i>✓</i>				
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3		KJ/JLM		
	Est Rev:G As per Rev C 06-11-08 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28042	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch 1 D2804-2 Bracket B41740	<i>SB 08/12/23 20</i>
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Stop Pick: Qty Part Number Description Batch 1 D2805-2 Stop B41707	<i>SB 08/12/23 21</i>
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing B37727	<i>SB 08/12/23 22</i>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804	<i>SB 08/12/23 23</i>

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/12/23 (a)

6.0 POWDER COATING

POWDER COATING



M109996

(X) 2X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:45

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:15

m 1 08/12/23

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ep08/12/23

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

Ep08/12/23

9.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M109147

Ep08/12/23

10.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M109535

Ep08/12/23

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Drawing Name: BRACKET ASSEMBLY

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Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 NAS151H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS151H3

Washer

11102101

A/R LPS-3

Corrosion Spray

1109929

Ep08/12/23

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

Ep08/12/23(2)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 08/17/23

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ep08/14/23(2)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



08/12/24 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

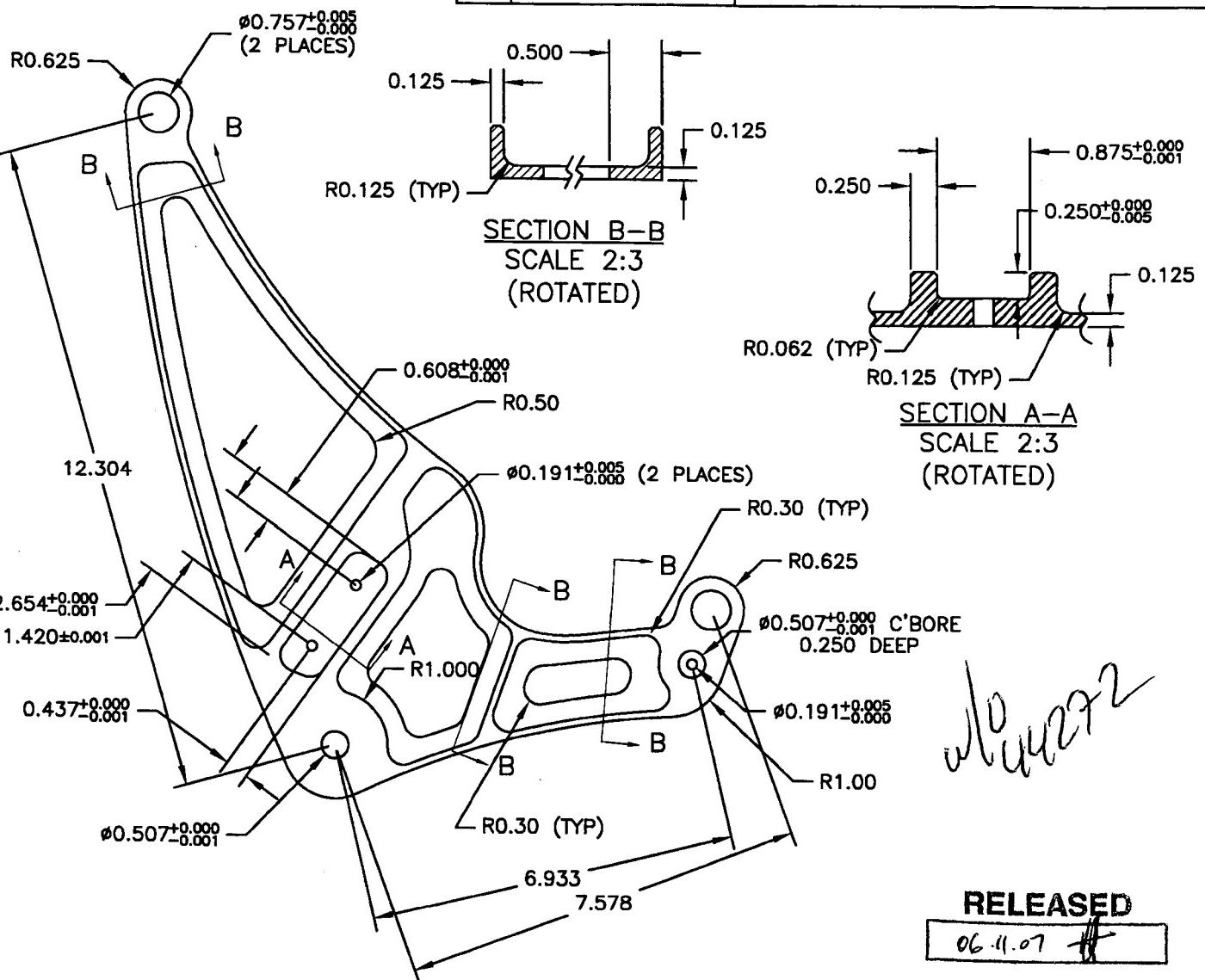


Ep08/12/23

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804
DATE 06.10.16		REV. C SHEET 1 OF 2
		TITLE STA 155 BRACKET
		SCALE 1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE



RELEASED

06.11.07 *[Signature]*

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

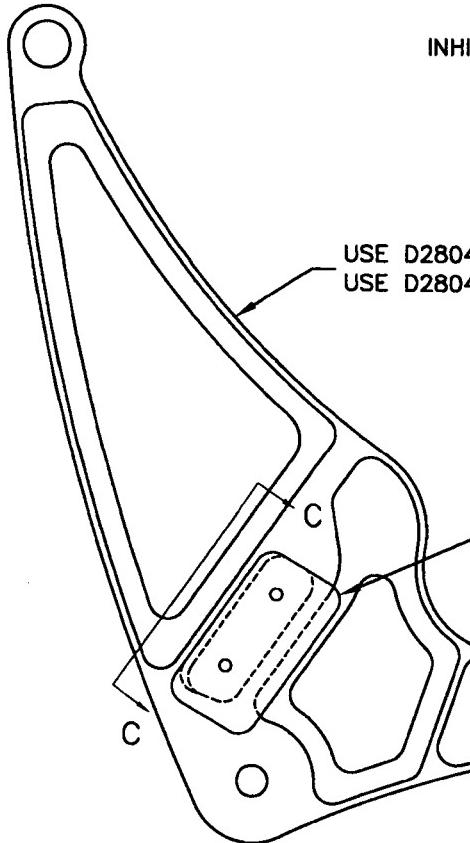
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDprt"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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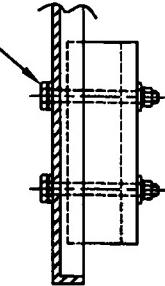
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

Wb44272

RELEASED

06.11.07 *[initials]*

D2804-041/-043 BRACKET ASS'Y (SHOWN),
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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